

load



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2573
Job Sheet 185373



Part No: D2573

Job Qty: 12 ea

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 11/9/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV F IPP: I As Per RevE 06-01-27 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining		SBL 18/12/19
100	CNC Vertical Machining	12 pcs	11/9/18	11/9/18	1.01	20.00	HAAS 1		SBL 18/12/19
110	Mill Conv	12 pcs	11/9/18	11/9/18	0.00	2.00	Mill Conv 1		SBL 18/12/19
130	QC	12 pcs	11/9/18	11/9/18	0.00	0.00	QC8		18/12/20
140	HandFinish	12 pcs	11/9/18	11/9/18	0.00	0.56	HandFinish1		D.B. 18/12/20
150	Powdercoat	12 pcs	11/9/18	11/9/18	0.00	0.46	Powdercoat1		BR 18-12-20
160	QC	12 pcs	11/9/18	11/9/18	0.00	0.00	QC3		JAN 07 2019 63
170	Packaging	12 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3		9-89
180	QC21-SA	12 Ea	11/9/18	11/9/18	0.00	0.00	QC21		21

Part Op 100 - Program Batch No. 5136886

Descriptions: 110 - Machine keyway as per dwg D2573 & D2574

150 - START TIME: 7:30 A.T. 300° FINISH: 8:00

M138951.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	12 Ea (1 ea)	90-Start up Operation	1x 5082692 11x 5133600

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	12	27	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Aft Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Aft Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Aft Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		

Plex 10/25/18 1:05 PM dart.white.jesse



Container No: S136886



Part: D2573

Job No: 185373

Serial No/Batch: S136886

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/11/18

5	Saddle, Aft Outboard	7.990Inches	+ 0.020 - 0.000	8.010 7.990
6	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
7	Saddle, Aft Outboard	0.257Inches	+ 0.005 - 0.000	0.262 0.257
8	Saddle, Aft Outboard	0.375Inches	+ 0.005 - 0.000	0.380 0.375
9	Saddle, Aft Outboard	0.490Inches	+ 0.020 - 0.000	0.510 0.490
10	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
11	Saddle, Aft Outboard	0.558Inches	+ 0.020 - 0.000	0.578 0.558
12	Saddle, Aft Outboard	1.174Inches	+ 0.010 - 0.000	1.184 1.174
13	Saddle, Aft Outboard	1.365Inches	+ 0.010 - 0.000	1.375 1.365
14	Saddle, Aft Outboard	2.495Inches	+ 0.010 - 0.000	2.505 2.495
15	Saddle, Aft Outboard	4.119Inches	+ 0.010 - 0.000	4.129 4.119
16	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
17	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
18	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
19	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
20	Saddle, Aft Outboard	0.178Inches	+ 0.020 - 0.000	0.198 0.178
21	Saddle, Aft Outboard	3.210Inches	+ 0.040 - 0.000	3.250 3.210
22	Saddle, Aft Outboard	0.230Inches	+ 0.020 - 0.000	0.250 0.230
23	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
24	Saddle, Aft Outboard	0.308Inches	+ 0.005 - 0.000	0.313 0.308
25	Saddle, Aft Outboard	0.760Inches	+ 0.005 - 0.000	0.765 0.760
26	Saddle, Aft Outboard	0.352Inches	+ 0.020 - 0.000	0.372 0.352
27	Saddle, Aft Outboard	0.470Inches	+ 0.060 - 0.000	0.530 0.470
28	Saddle, Aft Outboard	0.615Inches	+ 0.020 - 0.000	0.635 0.615
29	Saddle, Aft Outboard	0.053Inches	+ 0.020 - 0.000	0.073 0.053
30	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
31	Saddle, Aft Outboard	1.500Inches	+ 0.020 - 0.000	1.520 1.500
32	Saddle, Aft Outboard	0.115Inches	+ 0.020 - 0.000	0.135 0.115
33	Saddle, Aft Outboard	0.240Inches	+ 0.040 - 0.000	0.280 0.240
34	Saddle, Aft Outboard	0.240Inches	+ 0.020 - 0.000	0.260 0.240
35	Saddle, Aft Outboard	2.000Inches	+ 0.020 - 0.000	2.020 2.000
36	Saddle, Aft Outboard	0.023Inches	+ 0.020 - 0.000	0.043 0.023

DART AEROSPACE LTD	Work Order: 185 373
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.002	8.002	8.002		
F	0.490	0.510		0.501	0.505	0.504	0.500		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.375	0.370	0.378	0.378		
I	0.490	0.510		0.501	0.5015	0.500	0.5015		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.568	0.568	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.125	0.125	0.129	0.125		
Q	0.115	0.135		0.125	0.124	0.124	0.124		
R	0.240	0.260		0.254	0.253	0.253	0.253		
S	0.115	0.135		0.128	0.128	0.134	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.228	3.228		
V	0.230	0.250		0.240	0.241	0.241	0.242		
W	0.115	0.135		0.130	0.128	0.129	0.127		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.626	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.253	0.252	0.252		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.25	0.250	0.250	0.250		
AH	0.240	0.260		0.250	0.255	0.255	0.255		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		0.043	0.043	0.043	0.043		
Accept/Reject									

Measured by:	DAS
Date:	9-89 15/12/19

Audited by:	mk
Date:	15/12/20

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 185 373
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5 #	6 #	7 #	8 #		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.499	.498	.497	.497		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.130	.130	.130	.128		
Q	0.115	0.135		.124	.124	.124	.124		
R	0.240	0.260		.253	.253	.254	.253		
S	0.115	0.135		.125	.125	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.126	.125	.125	.126		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.368	.368	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.625	.624	.624		
AC	0.053	0.073		.065	.065	.065	.065		
AD	0.240	0.260		.251	.251	.251	.251		
AE	1.500	1.520		1.510	1.510	1.510	1.510		
AF	0.115	0.135		.125	.125	.125	.122		
AG	0.240	0.280		.260	.250	.250	.255		
AH	0.240	0.260		.250	.249	.249	.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: DAS	Audited by: <i>[Signature]</i>
Date: 57 18/12/19	Date: 18/12/20
9-89	

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
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DART AEROSPACE LTD	Work Order: 185373
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9 ¹	10 ²	11 ³	12 ⁴		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1750	1750	1750	1750		
C	3.495	3.505		3500	3500	3500	3500		
D	1.745	1.755		1750	1750	1750	1750		
E	7.990	8.010		8000	8000	8000	8000		
F	0.490	0.510		500	495	500	502		
G	0.257	0.262		257	257	257	257		
H	0.375	0.380		378	378	378	378		
I	0.490	0.510		500	500	500	500		
J	1.174	1.184		1179	1179	1179	1179		
K	0.558	0.578		567	567	567	566		
L	1.174	1.184		1179	1179	1179	1179		
M	1.365	1.375		1370	1370	1370	1370		
N	2.495	2.505		2500	2500	2500	2500		
O	4.119	4.129		4124	4124	4124	4124		
P	0.115	0.135		130	130	128	128		
Q	0.115	0.135		125	124	125	125		
R	0.240	0.260		253	253	253	253		
S	0.115	0.135		123	126	126	124		
T	0.178	0.198		188	188	188	188		
U	3.210	3.250		3230	3230	3230	3230		
V	0.230	0.250		242	242	241	240		
W	0.115	0.135		125	125	126	126		
X	0.308	0.313		311	311	311	310		
Y	0.760	0.765		760	760	760	760		
Z	0.352	0.372		368	368	367	367		
AA	0.470	0.530		500	500	500	500		
AB	0.615	0.635		624	624	625	624		
AC	0.053	0.073		065	065	065	068		
AD	0.240	0.260		252	253	251	251		
AE	1.500	1.520		1510	1510	1510	1510		
AF	0.115	0.135		126	128	122	123		
AG	0.240	0.280		255	260	260	260		
AH	0.240	0.260		255	251	245	247		
AI	2.000	2.020		2000	2000	2000	2000		
AJ	0.023	0.043		033	033	033	033		
Accept/Reject									

Measured by:	57
Date:	9-89 18/12/19

Audited by:	1
Date:	18/12/20

Rev	Date	Change	Revised by	Approved
B	02.09.26	Re-format; Added Rev. D	KJ	
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